

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003606**Date Inspected:** 26-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1430**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2230**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi and Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** deck panels / skin plates and stiffeners**Summary of Items Observed:****Tower Shop – Bay 1**

Caltrans Quality Assurance Inspector George Goulet (QA Inspector) observed personnel grinding on skin plates and stiffeners straightening. Twenty-five of the thirty-five ZPMC workers in this bay appeared to be reswtraining or staightening the skin plate of a skin plate - 4 stiffener assembly using hydraulic and screw jacks. No welding was observed being performed.

Tower Shop – Bay 2

QA Inspector ZPMC workers another skin plate - stiffener assembly being fit-up using hydraulic jacks similar to the ope3ration in Bay 1 as noted above. Forty-five workers were present in this shop.

Heavy Duty Machine Shop – Bay 3:

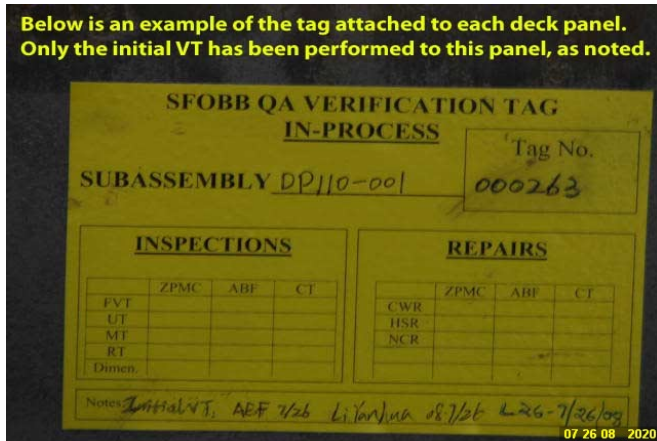
QA Inspector performed final VT on DP110-001 and DP137-001 with ABF QC Kevin Chen, ZPMC CWI Li Yan Hua, and ZPMC CWI Chen Xi. All welds appeared to be in compliance with contract documents, in concurrence with the above noted QC and CWI's.

Twenty-five deck panels were in the bay. Twenty-one ZPMC workers were present in addition to those noted above. No welding was observed being performed.

WELDING INSPECTION REPORT

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Below is an example of the tag attached to each deck panel.
Only the initial VT has been performed to this panel, as noted.



SFOBB QA VERIFICATION TAG			
IN-PROCESS			
SUBASSEMBLY DP110-001			Tag No. 000263
INSPECTIONS		REPAIRS	
FVT	ZPMC	ABF	CT
UT			
MT			
RT			
Dimen.			
Notes: Initial VT, AEF 7/26, L.Yan/ua 08/26, L26-7/26/09			
07 26 08 2020			



Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco, 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Goulet, George

Quality Assurance Inspector

Reviewed By: Carreon, Albert

QA Reviewer